

Date: Monday, 28/04/2008 8:13:24 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LITTER DECKPLATE 350
 Job Number : 38810
 Estimate Number : 10357
 P.O. Number :
 This Issue : 28/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2344
 First Issue : // Type : MACHINED PARTS Drawing Number : D2344 REV F
 Previous Run : 36850 Project Number : N/A
 Material :
 Due Date : 15/05/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JLD 08-4-28
 Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC
 Est Rev:E 07-07-04 Asper Rev F JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.7823 sf(s)/Unit Total : 15.6450 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch 162942

B 8-4-29



2.0 WATER JET F F FLOW WATER JET



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 28/04/08 (22)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL/MED FAB

1-Deburr sharp edges

B 8-4-29

2-Countersink holes per Dwg D2344

B 08/05/01 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 38810

Part Number: D2344

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/02 (X22)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/05/02

(22X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

08-05-02

(X22)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/05/02

(22X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: 185

8/5/02

(22X)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06

Job Completion



M. 08-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38810
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1	

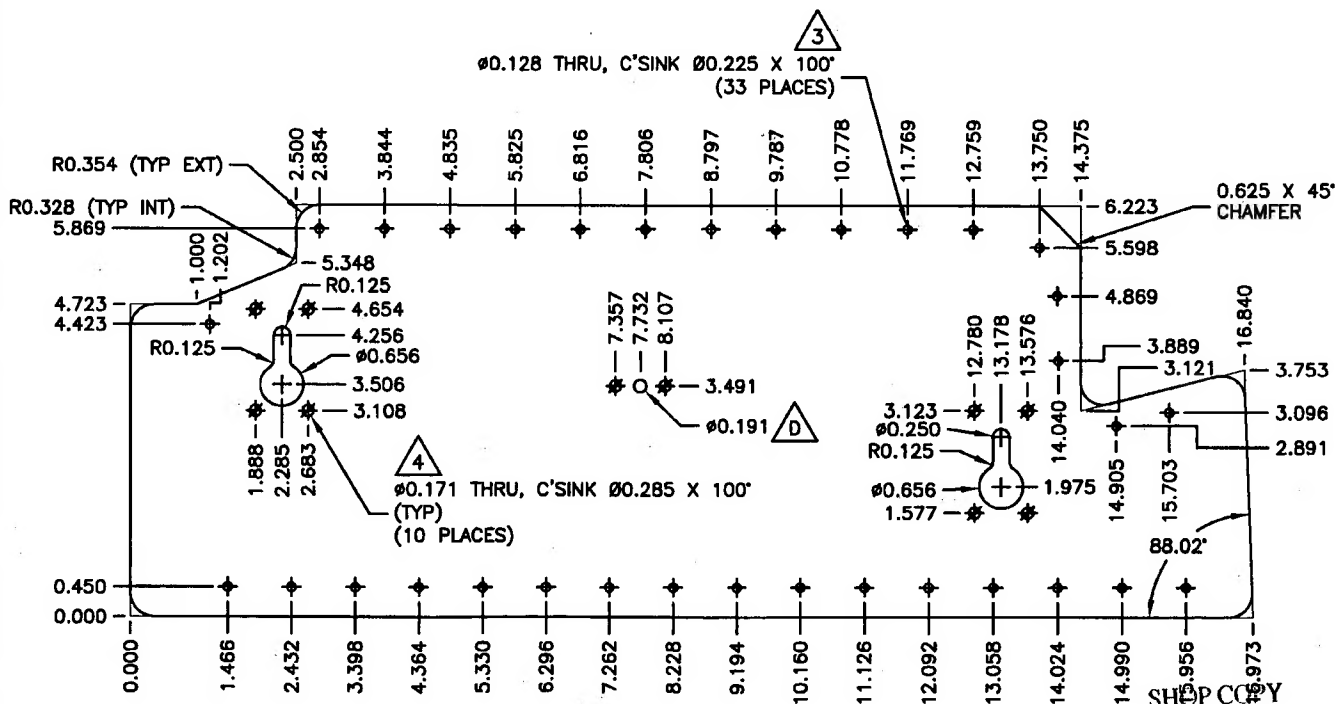
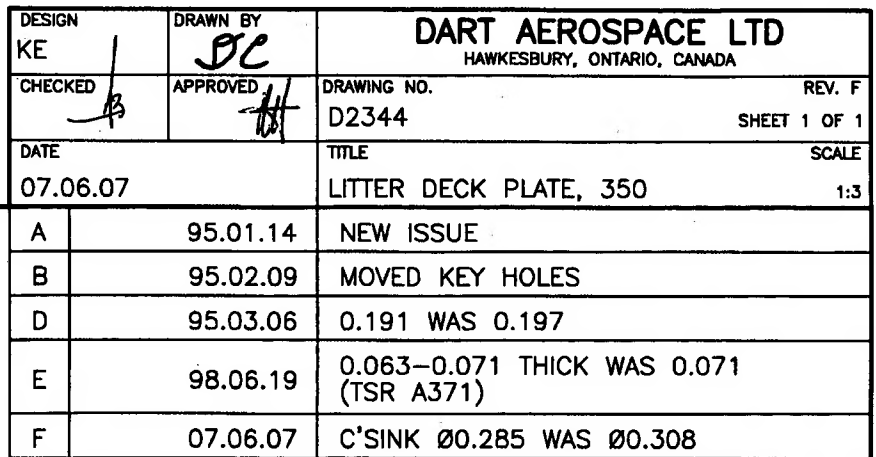
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.228	*			
5.598	+/-0.010	5.599	*			
4.869	+/-0.010	4.871	*			
3.889	+/-0.010	3.894	*			
3.096	+/-0.010	3.098	*			
2.891	+/-0.010	2.894	*			
16.973	+/-0.010	16.973	*			
0.450	+/-0.010	.450	*			
4.423	+/-0.010	4.425	*			
4.723	+/-0.010	4.723	*			
1.202	+/-0.010	1.202	*			
5.869	+/-0.010	5.871	*			
4.654	+/-0.010	4.655	*			
Ø0.656	+0.005/-0.000	.656	*			
1.888	+/-0.010	1.888	*			
2.285	+/-0.010	2.285	*			
2.683	+/-0.010	2.681	*			
Ø0.171	+0.005/-0.000	.171	*			
3.491	+/-0.010	3.494	*			
Ø0.191	+0.005/-0.000	.191	*			
3.123	+/-0.010	3.125	*			
1.975	+/-0.010	1.973	*			
Ø0.128	+0.005/-0.001	.130	*			

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	8-4-29	Date:	08/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE



**UNCONTROLLED COPY
SUBJECT TO AMENDMENT**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED Φ TO $\Phi 0.225 \times 100^\circ$
- 4) COUNTERSINK HOLES MARKED Φ TO $\Phi 0.285 \times 100^\circ$
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

WITHOUT NOTICE
WORK ORDER
O. 38810

RELEASED

07.06.22

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